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D350-591-311
Job Sheet 183400



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/17/18

Job Tracking No:

Due Date: 9/21/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/21/18	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	1 pcs		9/21/18	0.00	0.99	Large Fab 2		NR
120	QC	1 pcs		9/21/18	0.00	0.00	QC9		NR
130	QC	1 pcs		9/21/18	0.00	0.00	QC5		NR
140	HandFinish	1 pcs		9/21/18	0.00	0.18	HandFinish1		NR
150	QC	1 pcs		9/21/18	0.00	0.00	QC7-2		NR
180	Large Fab	1 pcs		9/21/18	0.00	0.99	Large Fab 2		SDAEI
190	QC	1 pcs		9/21/18	0.00	0.00	QC10		38 DAS
200	QC	1 pcs		9/21/18	0.00	0.00	QC5		9-89 38
210	HandFinish	1 pcs		9/21/18	0.00	0.18	HandFinish1		DR 18/09/20
220	Powdercoat	1 pcs		9/21/18	0.00	0.29	Powdercoat1		DR 18-9-24
230	HandFinish	1 pcs		9/21/18	0.00	0.18	HandFinish3		DR 18-09-24
240	QC	1 pcs		9/21/18	0.00	0.00	QC3		38
250	Packaging	1 pcs		9/21/18	0.00	0.00	Packaging1-3		9-89 38
260	QC	1 pcs		9/21/18	0.00	0.00	QC4		9-89 38
270	Packaging	1 pcs		9/21/18	0.00	0.00	Packaging3-1		9-89 38
275	DC	1 pcs		9/21/18	0.00	0.00	DC		21 OCT 03 2018
280	QC21-FG	1 Ea		9/21/18	0.00	0.00	QC21		21 OCT 03 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 10:45 OVEN TEMPERATURE: 320° FINISH TIME: 11:15

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	5104284
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	5108046
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5109677
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	5109745
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	5108799
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	5057529
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	5089307
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	5089302
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	5099504
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	5110581
D2618	Bushing	2 Ea (2 ea)	250-Packaging	5089996
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	5104532
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	5113203
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	5119310
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	5094592
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	5094592
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	5083541
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	5095293
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	5089299
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	5093723

Job Allocations

DART
AEROSPACE

 1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S110926



Part: D350-591-311

Job No: 183400

Serial No/Batch: S110926

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11 Date: 04/12/21, BRAZIL 1

Required	Inventory	Allocated
2	121	0
2	111	0
1	1	0
1	28	0
2	96	0
16	460	0
2	403	0
8	818	0
2	346	0
4	219	0
2	195	0
2	238	0
2	44	0
1	4	0
2	3,288	0
8	4,086	0
2	864	0
4	2,245	0
16	7,192	0
4	1,636	0

Part Specifications

Specifications could not be found.

Plex 9/17/18 4:12 PM Dart.Gagnon.Michelle

H7x1x9660115

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY